

Date: Monday, 2/11/2008 2:12:00 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, RH, 206  
 Job Number : 37331  
 Estimate Number : 10523  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D26652  
 Drawing Number : D2665 REV. D  
 Project Number : N/A  
 Drawing Revision : D  
 First Issue : / / Type : MACHINED PARTS Material :  
 Previous Run : 36626 Due Date : 2/28/2008 Qty: 10 Um: Each  
 Written By :  
 Checked & Approved By : 08 02 11  
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in  
 house process EC  
 Est Rev:D As per Rev D 07-03-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

B34644

27 05/05/04

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Program batch number

2- Machine Step # 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step # 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step # 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

DIP 08/06/12

08/05/04

(P10) →

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

DIP 08/06/12

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/06/12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

S 08/06/12 (710)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-2 PAR #: NA Fault Category: Roll Machine NCR: Yes No DQA: D Date: 08/06/14  
 QA: N/C Closed: D Date: 08/06/14

NCR: 37331		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/06/13	#	Due to disorganization on A Run of SADDLES were stopped. upon Re starting it was found that the 0.188" RAD is actually a 0.28" RAD	CP 08-06-13 pu QSI 042	-5 parts were affected. PARTS ACCEPTABLE	DSP 08/06/18	S 08/06/14	CP 08-06-13 pu QSI 042	S 08/06/13
		R.C. wrong RAD tool was used Lack of attention						S 08/06/13

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 2:12:01 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, RH, 206

Job Number: 37331

Part Number: D26652

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-J 08/06/19

7.0

POWDER COATING

POWDER COATING



M 107925

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 08-06-19

D26652  
1337331  
19/06/2008  
S.024 13.44  
#1 321.4 F  
#2 --- F  
#3 304 rick  
#4 --- F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-J 08/06/19

9.0

PACKAGING 1

PACKAGING RESOURCE #1



10X

Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: B6

8/6/20

SD

08/06/23

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-06-23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>37331</b>
<b>Description: 206 Saddle, Outboard, Right side</b>	<b>Part Number:</b>	<b>D2665-2</b>
<b>Inspection Dwg: D2665 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.115	.115	0.128	0.118		
B	0.100	0.140		.114	0.114	0.110	0.110		
C	1.125	1.145		1.250	1.135	1.135	1.1336		
D	0.615	0.685		.665	.670	0.680	0.675		
E	0.240	0.260		.248	.249	0.250	0.250		
F	1.313	1.343		1.321	1.323	1.326	1.326		
G	0.210	0.230		.223	.223	0.220	0.220		
H	0.100	0.180		.173	.170	0.175	0.170		
I	2.470	2.510		2.496	2.499	2.500	2.500		
J	1.565	1.585		1.575	1.575	1.575	1.574		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.100	0.120		.107	.108	0.110	0.110		
M	0.990	1.010		0.995	0.995	0.996	0.994		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.001	6.001	6.003	6.002		
P	1.245	1.255		1.250	1.250	1.2486	1.249		
Q	2.495	2.505		2.500	2.500	2.498	2.499		
R	0.313	0.318		.313	.3155	0.3155	0.3155		
S	0.315	0.322		.321	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.787	0.807		.797	.797	0.797	0.797		
W	0.540	0.560		.551	.551	0.548	0.548		
X	1.674	1.684		1.679	1.679	1.679	1.680		
Y	0.257	0.262		.258	.259	0.259	0.260		
Z	0.912	0.932		.920	.922	0.922	0.921		
AA	0.490	0.510		.505	0.506	0.497	0.502		
AB	0.178	0.198		.181.250	.250	0.188	.250		
AC						.2505			
AD									
AE									
AF									
Accept/Reject									

Measured by:	<i>20</i>
Date:	<i>08/08/09</i>

Audited by:	<i>S</i>
Date:	<i>08/06/09</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37331
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	5	6	7	8		
A	0.100	0.140		0.127	0.114	0.114	0.115		
B	0.100	0.140		0.116	0.127	0.124	0.124		
C	1.125	1.145		1.133	1.129	1.129	1.130		
D	0.615	0.685		0.670	0.685	0.685	0.680		
E	0.240	0.260		0.249	0.253	0.253	0.253		
F	1.313	1.343		1.321	1.323	1.323	1.323		
G	0.210	0.230		0.219	0.219	0.219	0.221		
H	0.100	0.180		0.160	0.140	0.140	0.140		
I	2.470	2.510		2.500	2.499	2.501	2.499		
J	1.565	1.585		1.578	1.568	1.568	1.570		
K	0.235	0.240		0.239	0.239	0.239	0.239		
L	0.100	0.120		0.110	0.110	0.110	0.110		
M	0.990	1.010		0.993	0.993	0.993	0.997		
N	0.510	0.515		0.511	0.511	0.511	0.511		
O	5.990	6.010		6.000	6.002	6.002	6.002		
P	1.245	1.255		1.248	1.249	1.249	1.250		
Q	2.495	2.505		2.499	2.500	2.500	2.499		
R	0.313	0.318		0.315	0.315	0.315	0.315		
S	0.315	0.322		0.322	0.322	0.322	0.322		
T	2.495	2.505		2.500	2.498	2.499	2.500		
U	1.357	1.367		1.362	1.363	1.362	1.363		
V	0.787	0.807		0.797	0.798	0.798	0.795		
W	0.540	0.560		0.548	0.552	0.550	0.550		
X	1.674	1.684		1.679	1.679	1.680	1.679		
Y	0.257	0.262		0.260	0.259	0.260	0.260		
Z	0.912	0.932		0.922	0.921	0.920	0.918		
AA	0.490	0.510		0.498	0.498	0.499	0.498		
AB	0.178	0.198		0.250	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <u>DTP</u>	Audited by: <u>[Signature]</u>
Date: <u>08/06/13</u>	Date: <u>08/06/13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 37331
<b>Description:</b> 206 Saddle, Outboard, Right side	<b>Part Number:</b> D2665-2
<b>Inspection Dwg:</b> D2665 Rev. D	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev.D C and record below:

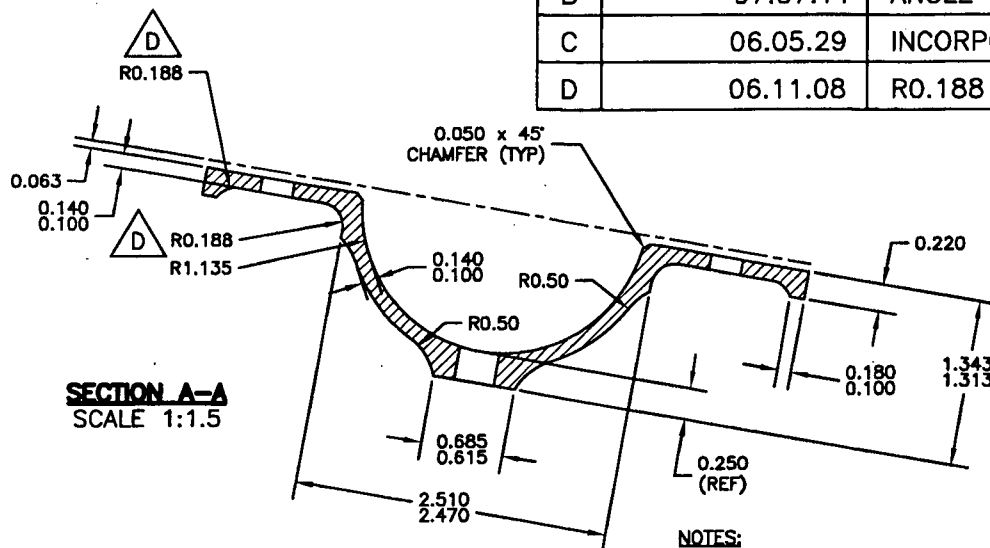
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		0.114	0.1125				
B	0.100	0.140		0.126	0.125				
C	1.125	1.145		1.130	1.128				
D	0.615	0.685		0.680	0.680				
E	0.240	0.260		0.253	0.254				
F	1.313	1.343		1.323	1.322				
G	0.210	0.230		0.220	0.219				
H	0.100	0.180		0.140	0.140				
I	2.470	2.510		2.500	2.500				
J	1.565	1.585		1.5695	1.5675				
K	0.235	0.240		0.239	0.239				
L	0.100	0.120		0.110	0.110				
M	0.990	1.010		0.995	0.995				
N	0.510	0.515		0.511	0.511				
O	5.990	6.010		6.001	6.001				
P	1.245	1.255		1.249	1.250				
Q	2.495	2.505		2.500	2.500				
R	0.313	0.318		0.3155	0.3155				
S	0.315	0.322		0.322	0.322				
T	2.495	2.505		2.500	2.500				
U	1.357	1.367		1.362	1.363				
V	0.787	0.807		0.797	0.797				
W	0.540	0.560		0.5495	0.550				
X	1.674	1.684		1.679	1.680				
Y	0.257	0.262		0.260	0.260				
Z	0.912	0.932		0.920	0.918				
AA	0.490	0.510		0.497	0.501				
AB	0.178	0.198		0.180	0.188				
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: <i>DTF</i>	Audited by: <i>S</i>
Date: 08/06/16	Date: 08/06/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

**DART**

DESIGN <b>AH</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
CHECKED <b>PH</b>	APPROVED <b>AH</b>	DRAWING NO. <b>D2665</b>	REV. D SHEET 1 OF 1
DATE <b>06.11.08</b>	TITLE <b>SADDLE FWD OUTSIDE HIGH</b>	SCALE <b>1:3</b>	
<b>A</b>	<b>97.03.25</b>	<b>NEW ISSUE</b>	
<b>B</b>	<b>97.07.11</b>	<b>ANGLE AND NOTES ADDED</b>	
<b>C</b>	<b>06.05.29</b>	<b>INCORPORATE DEO 9122, 9102, 9095</b>	
<b>D</b>	<b>06.11.08</b>	<b>R0.188 WAS R0.30; Ø0.316 WAS Ø0.313</b>	

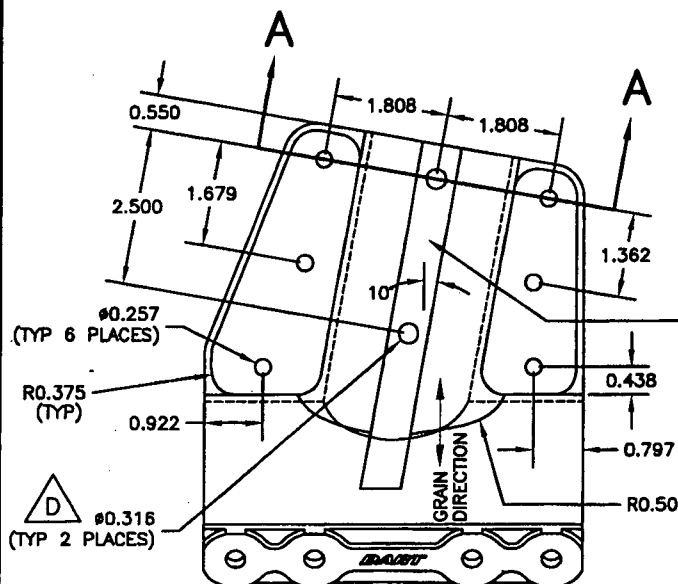


RELEASED

07.02.12

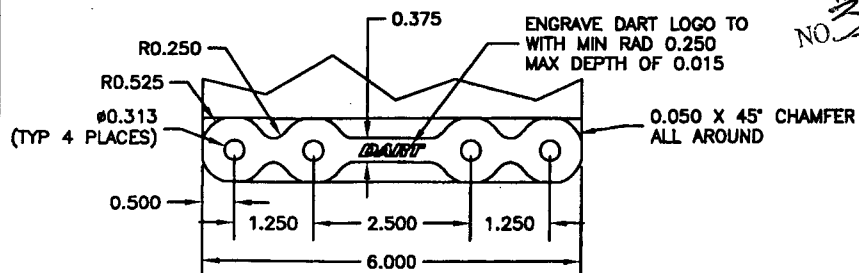
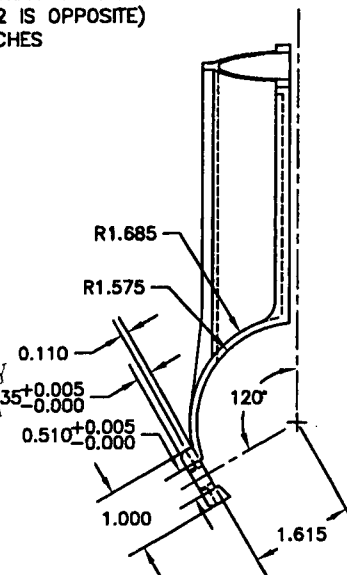
## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART  
NUMBER AND  
BATCH NUMBER  
TO MAX DEPTH  
OF 0.010 WITH  
MIN RADIUS  
OF 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37331

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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